

Date: Wednesday, 3/8/2006 10:38:37 AM
 User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BLOWER MOTOR SUPPORT	
Job Number :	26125			
Estimate Number :	12308			
P.O. Number :	N/A	Part Number :	D34711	
This Issue :	3/8/2006	Drawing Number :	D3471 REV.A	
Prsht Rev. :	NC	Project Number :	N/A	
First Issue :	N/A	Drawing Revision :	A	
Previous Run :	N/A	Material :	N/A	
Written By :	<i>See comment below</i>		Due Date :	3/31/2006
Checked & Approved By :	<i>06.03.08</i>		Qty:	10 Um: Each
Comment :	est rev A 06.03.02 New issue EC			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	OUTSIDE SERVICE	OUTSIDE SERVICES
-----	-----------------	------------------

**Comment:** Sub-Contracting OUTSIDE SERVICESIssue P/O: *00000768*

Email or Ship DXF file to vendor

Cut per Dwg D3471 flat pattern D3471-1F

possible supplier: GFI

Material release note required

2.0	D34711F	BASE FLAT PATTERN
-----	---------	-------------------

**Comment:** Qty.: 1.0000 sf(s)/Unit Total : *10* 8.0000 sf(s)

SUPPORT FLAT PATTERN

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------

**Comment:** PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------

**Comment:** DIMENSIONAL CHECK

Ensure Material certification comply to Dwg D3471

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------

**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

2-Bend as per dwg D3471

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ _____ Date: 06/03/30
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/8/2006 10:38:37 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLOWER MOTOR SUPPORT

Job Number: 26125

Part Number: D34711

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 06:03:29 (10)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06:03:29 (10)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST439

CZ06/03/29 10

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/03/29 (10)

Job Completion



06/03/29

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

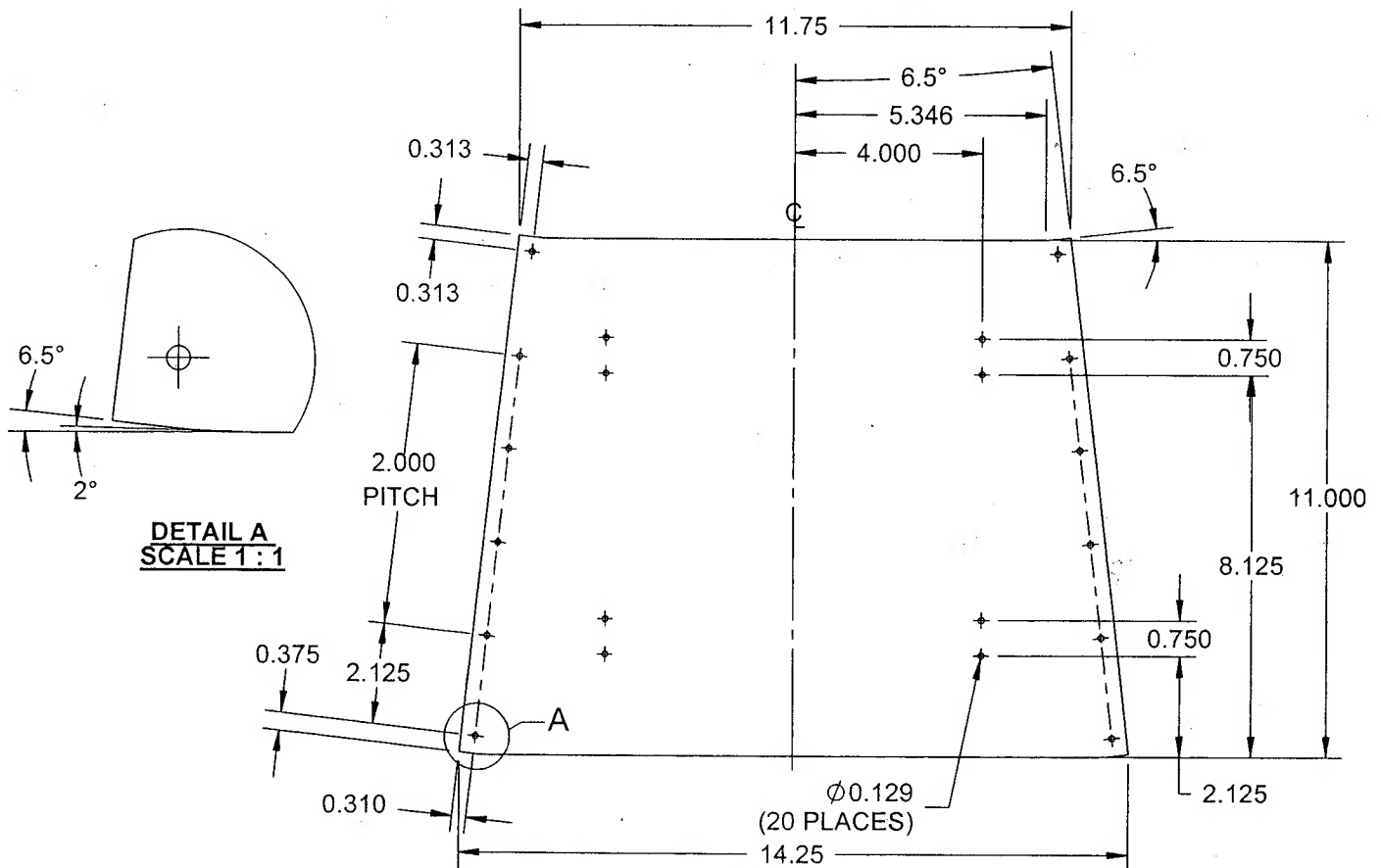
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

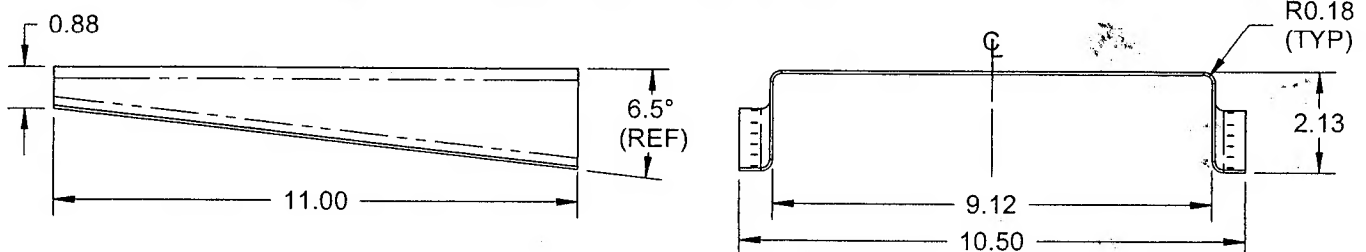
NOTE: Date & initial all entries

PRELIMINARY ISSUE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3471	REV. A SHEET 3 OF 5
DATE 05.12.21	TITLE BLOWER MOTOR SUPPORT		SCALE 1:4



D3471-1F BASE FLAT PATTERN



D3471-1 BASE BENDING DETAIL

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.040" THICK)
PER QQ-A-250/4 OR AMS 4037
(REF. DART SPEC. M2024T3S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) PART IS SYMMETRICAL ABOUT CENTER LINE
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

FAX 1 847 585 2500

CORUS ALUMINIUM

Corus Aluminij - Walzprodukte G. ...1
 100331 D-56033 Koblenz



INSPECTION CERTIFICATE (EN 10204/3.1) / TEST REPORT / APPROVED CERTIFICATE

NO.: 0879231 SERIAL-NO.: PAGE: 2 / 03
 PURCHASER: CORUS ALUMINIUM ROLLED ORDER NO. PURCH.: US-AIRCR. DEPOT-PRO
 PRODUCTS USA-A DIVIS ORDER NO. MAN.: 83418
 SCHAUMBURG, IL 60173 SPEC.: AMS4041+B209+GQ230/5
 CUSTOMER PART NO.:
 ITEM: 01 LOT: 102973 ALLOY/TEMPER: 2024 T3 ALCLAD 1230 PRODUCT: PLA
 QUANTITY: 344 DIMENSIONS: 0.040 x 48.00 x 144.00 INS

Other tests:

Dimensional check: OK
 Surface control: OK

Normative references:

BESTELLNORM/SPECIFICATION/NORME
 AMS 4041P+ASTM B 209-04+AMS-QQ-A-250/5A SEP1998

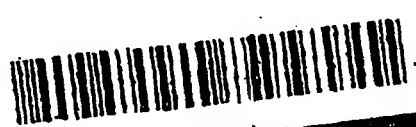
Bend test:

L-direction

LT-direction OK

ST-direction

te G.
Koblenz



corus

CERTIFICATE (EN 10204/3.1) / TEST REPORT / APPROVED CERTIFICATE

SERIAL-NO.:
CORUS ALUMINIUM ROLLED
PRODUCTS USA-A DIVIS
CHAUMBURG, IL 60173
CUSTOMER PART NO.:
ORDER NO. PURCH.: US-AIRCR. DEPOT-PRO
ORDER NO. MAN.: 83415
SPEC.:
AMS4041+BZ09+QQ250/5
PAGE: 3 / 03

THAT THE WHOLE OF THE SUPPLIES DETAILED HEREON HAVE BEEN
TESTED AND, UNLESS OTHERWISE STATED ABOVE, CONFORM IN ALL
WITH THE REQUIREMENTS OF THE SPECIFICATION, CONTRACT OR ORDER.

res:

inZ, the 25.08.03 SW

G. Mattler
Quality Assurance
Corus Aluminium
Werkzeuge GmbH
Koblenz

MAR-23-2006 04:24 FROM:

TO: 6049464153

Corus Aluminium Walzprodukte G.m.b.H.
Postfach 400331 · D-56033 Koblenz



corus

INSPECTION CERTIFICATE (EN 10204/3.1) / TEST REPORT / APPROVED CERTIFICATE

NO.: 0879231 SERIAL-NO.: PAGE: 1 / 03
PURCHASER: CORUS ALUMINIUM ROLLED ORDER NO. PURCH.: US-AIRCR.DEPOT-PRO
PRODUCTS USA-A DIVIS ORDER NO. MAN.: 83415
SCHAUMBURG, IL 60173 SPEC.: AMS4041+B209+QQ250/5
ITEM: 01 LOT: 102973 CUSTOMER PART NO.:
QUANTITY: 344 ALLOY/TEMPER: 2024 T3 ALCLAD 1230 PRODUCT: PLA
DIMENSIONS: 0.040 X 48.00 X 144.00 INS

RESULTS:

Mechanical properties:

Spec. No.	Y.S.	U.T.S.	El.
	KSI	KSI	%
Min. LT:	39,0	59,0	15,0
Max. LT:			
001	40,5	59,8	17,9
002	40,6	59,8	18,7
003	40,5	59,8	17,7
004	40,8	59,6	18,1

Chemical composition: in % , remainder Al

ALLOY:	ALLOY CORE	ALLOY LINER	ALLOY LINER
CAST-NO.	2024	1230 4	1230 4
	5-08-2914	142166-1	142166-1
Si	0,028	0,12	0,12
Fe	0,123	0,26	0,26
Cu	4,325	0,002	0,002
Mn	0,634	0,010	0,010
Mg	1,436	0,003	0,003
Cr	0,001	0,001	0,001
Zn	0,011	0,005	0,005
Ti	0,0278	0,019	0,019
B	0,0006	0,002	0,002
Zr	0,0006		
Pb	0,0016	0,0011	0,0011
Ni	0,0059		

